

Work Order ID 94401

94401

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Item ID: DSI 9613-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Door Hinge Modification

Start Date: 12/13/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/13/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____

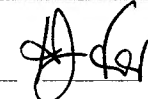
Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9613	A								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP DSI9613-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
15
2-89
12 12 13

2  MLS 12-12-13
(2)

12 12 13 x 2

DAS
15
2-89
12 12 13

2

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Item ID: DSI 9613-011

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N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Cargo Door Hinge Modification

Start Date: 12/13/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/13/12 Req'd Qty: 2.00

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Customer:


Reference:



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9613-011								
	Location: 								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

 12/12/1412/12/17 MF
12-12-17

Picklist Print

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Work Order ID: 94401

Parent Item: DSI 9613-011

Parent Item Name: Cargo Door Hinge Modification

Start Date: 12/13/12

Required Date: 12/13/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.05.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4632-1 Striker Plate		Manufactured	No			110	Each	2.0000	1	2	2		u
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		2							
				86207		2							
D4632-2 Striker Plate		Manufactured	No			110	Each	2.0000	1	2	2		u
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		2							
				86209		2							
MS24694-S47 Screw		Purchased	No			110	Each	28.0000	8	16	16		u
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST303		28							
				115622		8							
				122594		20							
MS27039-08-07 Screw		Purchased	No			110	Each	385.0000	8	16	16		u
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST307		385							
				122563		385							

SMS 27

SMS 27

SMS 28

SMS 27

Picklist Print

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Work Order ID: 94401

Parent Item: DSI 9613-011

Parent Item Name: Cargo Door Hinge Modification

Start Date: 12/13/12

Required Date: 12/13/12

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN832J

Purchased

No

110

Each

3,100.0000

8

16

WASHER

Location

Loc Qty

Loc Code

ST293

3100

119717

41

120422

43

123248

396

123348

1420

123352

200

123603

400

123900

600

16

h

NAS1149D0332J

Purchased

No

110

Each

3,491.0000

8

16

Washer

Location

Loc Qty

Loc Code

FP001

3491

122973

3491

16

h

MS21042L08

Purchased

No

110

Each

4,676.0000

8

16

Nut

Location

Loc Qty

Loc Code

ST315

4676

122141

167

122452

9

122814

500

123900

4000

16

h

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Shop Packet Print

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Work Order ID: 94401

Parent Item: DSI 9613-011

Parent Item Name: Cargo Door Hinge Modification

Start Date: 12/13/12

Required Date: 12/13/12

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

4,728.0000

8

16

Nut

Location

Loc Qty

Loc Code

FP001

141

122141

141

GA

419

122452

419

ST314

668

117885

32

119017

55

119075

138

123265

443

ST506

3500

123900

3500

Sho 27

16

✓

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Shop Packet Print

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DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. F AND ICA-D139-799 REV. 5

REF. FAA STC: SR02138SE

REF EASA STC EASA.10038656

PURPOSE

The purpose of this DSI is to clarify the installation of the D139-799-013 Cargo Door Fwd Opening Kit on aircraft that are equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors with two gas springs (see Figure 3b of IIN-D139-799 Rev. F).

PROCEDURE

Amend IIN-D139-799 Rev.F steps as follows:

- 3.2.1.2 Remove left/right hinges from the doors as shown in Figure 3a including the door open switches on the fwd hinge bracket. Remove left/right gas spring hinges (if installed) from the door as shown in Figure 3b. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, remove 3P5230A15631 and 3P5230A15731 hinge brackets from the airframe as shown in Figure 1 of this DSI.
- 3.2.2.10 Install the D4074-7 Striker Plate using 4 x CR3523-4 rivet as shown in Figure 5c Section G-G. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, trim Doorframe Channel as shown in Figure 2 of this DSI to allow space for alternate D4632-1 (LH) and D4632-2 (RH) striker plates. Install alternate D4632-1/-2 striker plate at the aft airframe hinge bracket location (see Figure 2 of this DSI). Transfer drill 4 x holes from 3P5340A31951 doubler to striker plate, and install using MS24694-S47 screw, NAS1149D0332J washer and MS21042L3 nut in 4 places.
- 3.2.2.11 Install D4074-1/-5 Bracket/Backing Plate using the existing holes in the cargo door as shown in Figure 5b Detail E. Plug holes at center of the door used for original gas springs using existing hardware. Torque screws per Table 1. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, plug existing holes with Hysol EA934NA. Locate D4074-1 bracket at bottom of existing recess and transfer hole locations to door as shown in Figure 4 of this DSI. Install D4074-1/-5 brackets using hardware shown in Figure 5b Detail E of IIN-D139-799 Rev. F.
- 3.2.2.12 Install D4074-3 Channel using existing hardware in original gas spring cut out as shown in Figure 5d Section I-I. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, trim Doorframe Cover as shown in Figure 3 of this DSI to expose bottom side of Doorframe Channel. Locate D4074-3 Channel as shown in Figure 3 of this DSI and transfer 4 x $\phi 0.173$ " (#17 drill) from the D4074-3 Channel to the Doorframe Channel. Install D4074-3 Channel using MS27039-0807 screw, NAS1149DN832J washer and MS21042L08 nut in 4 places.

PART LIST

Note: The following parts are included in D139-799-013 at CHG 005 and later. For customers who already have D139-799-013 at CHG 004 and earlier, procure the DSI 9613-011 kit from Dart.

QTY. -011-	PART NUMBER	DESCRIPTION
X	DSI 9613-011	CARGO DOOR HINGE MOD KIT
1	D4632-1	STRIKER PLATE
1	D4632-2	STRIKER PLATE
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	NAS1149DN832J	WASHER
8	NAS1149D0332J	WASHER
8	MS21042L08	NUT
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	12.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9613	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CARGO DOOR HINGE MOD	NTS
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